

Date: Wednesday, 6/6/2007 3:45:33 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 BEARPAW INSTALLATION KIT (48")
Job Number	: 32835		
Estimate Number	: 12283		
P.O. Number	: <u>N/A</u>	Part Number	: D205564011
This Issue	: 6/6/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D2521
First Issue	: <u>NA</u>	Project Number	: N/A
Previous Run	: 30338	Type	: MACHINED PARTS
		Drawing Revision	: J
		Material	: <u>NA</u>
		Due Date	: 7/10/2007
Written By	: _____	Qty:	<u>10</u> Um: Each
Checked & Approved By	: <u>07.06.07</u>		
Comment	: Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC		
	Est Rev:G 06-08-28 As per Rev E JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

5 4/10/17

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 13.6500 sf(s)/Unit Total : 136.5000 sf(s)
blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
Material: Black UHMW 1"
(MUHMWB10)
Batch: M105862

ML 07/10/15

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

mf 02/01/15

20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/10/15

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:45:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 32835

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2.5 01/10/16 (10)

6.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 3.7000 f(s)/Unit Total : 37.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion 308721

59

7.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block 32015

59

8.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer 30382

32025

59

9.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp 30386

59

10.0

D3544041

CLAMP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

CLAMP

Batch: 30376 28794 32864

4/10/16 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 01/10/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:45:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 32835

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0
HHH
G
(X10)

AN413A

Bolt



HHH

Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Batch: M101594

M108422

M105653

48

54

12.0
HHH

AN415A

Bolt



HHH

Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN4-15A

Bolt

M104072

54

13.0
HHH

AN960JD416

Washer



HHH

Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M104746

54

14.0
HHH
G
(X10)

MS21042L4

Nut



HHH

Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Nut

Batch: M104683

7/10/16 SD

(10X)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/10/17

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C

7/10/17 SD

(10X)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/10/18
W O KILGUS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32835
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓			
B	0.90	0.96	0.927	✓			
C	0.27	0.330	0.314	✓			
D	0.470	0.530	0.485	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	0.750	✓			
G	0.35	0.410	0.375	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.430	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.940	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.620	✓			
P	0.940	0.980	0.953	✓			
Q	18.97	19.03	19.000	✓			
R	0.350	0.410	0.380	✓			
S	0.740	0.780	0.756	✓			
T	0.240	0.280	0.260	✓			
U	0.370	0.410	0.390	✓			
V	0.740	0.780	0.770	✓			
W	0.740	0.780	0.760	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/10/12	Date:	07.10.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN #	DRAWN BY C B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32835

RELEASED

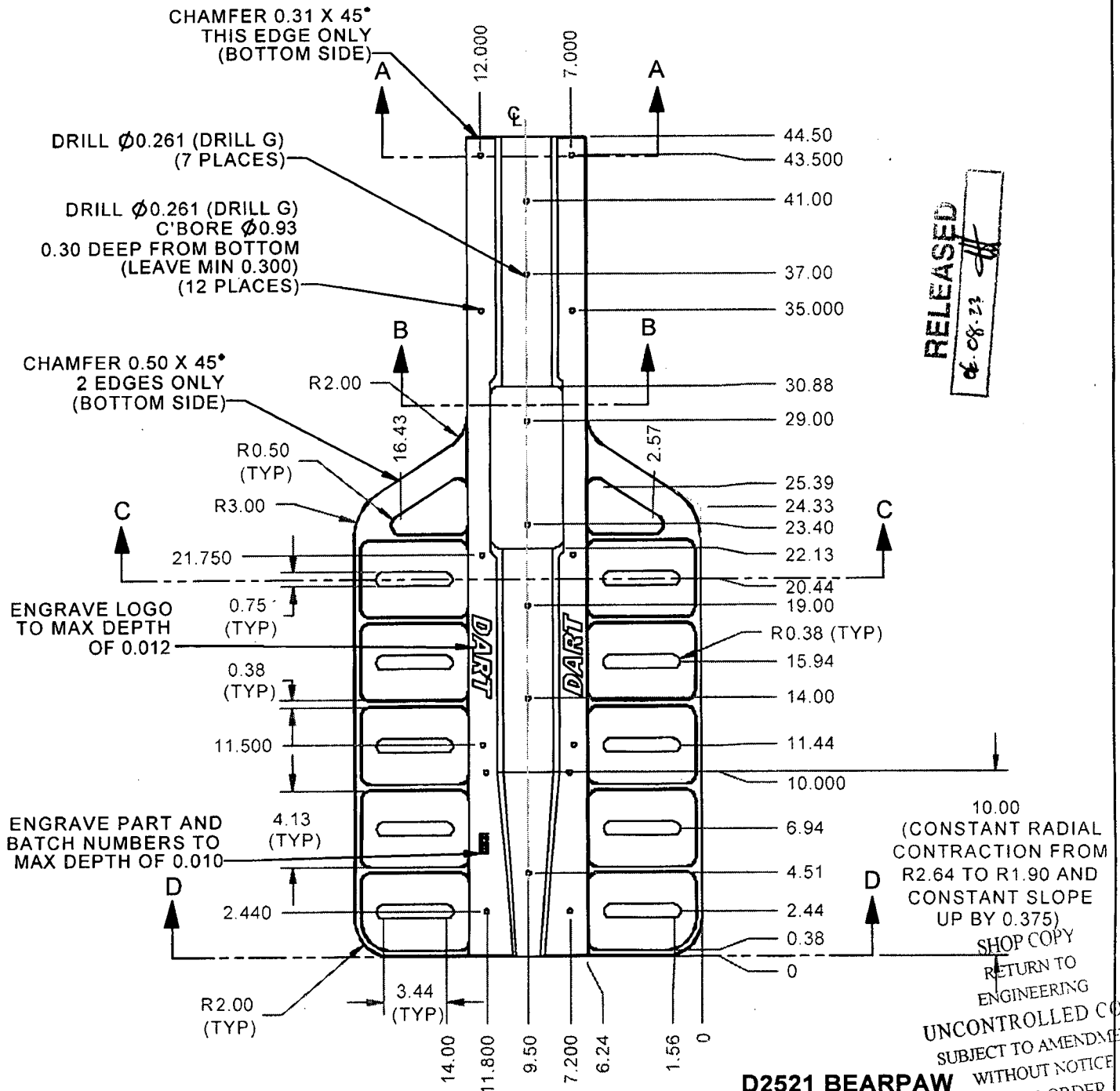
06 08.23 #

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
		D2521	SHEET 2 OF 3
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1:8

**NOTES:**

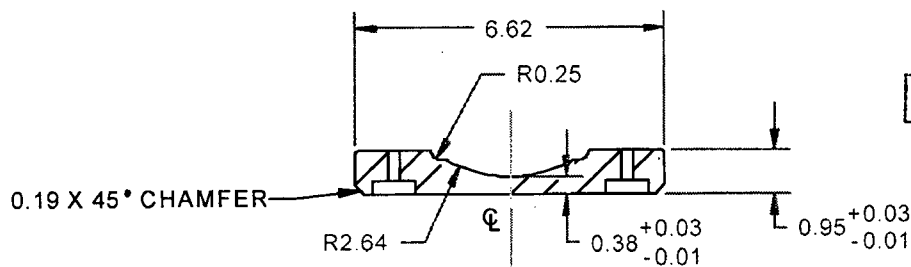
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

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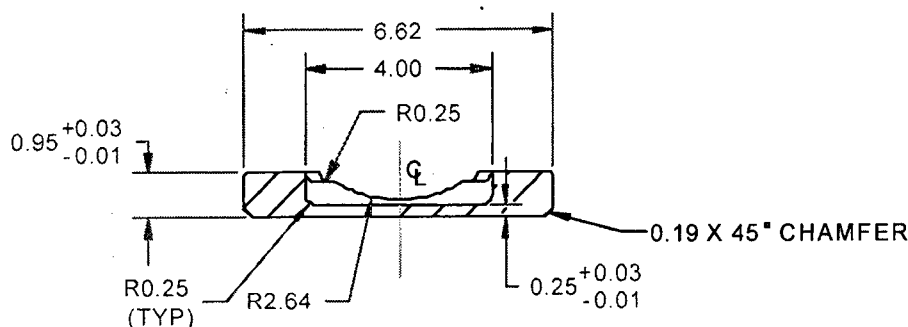
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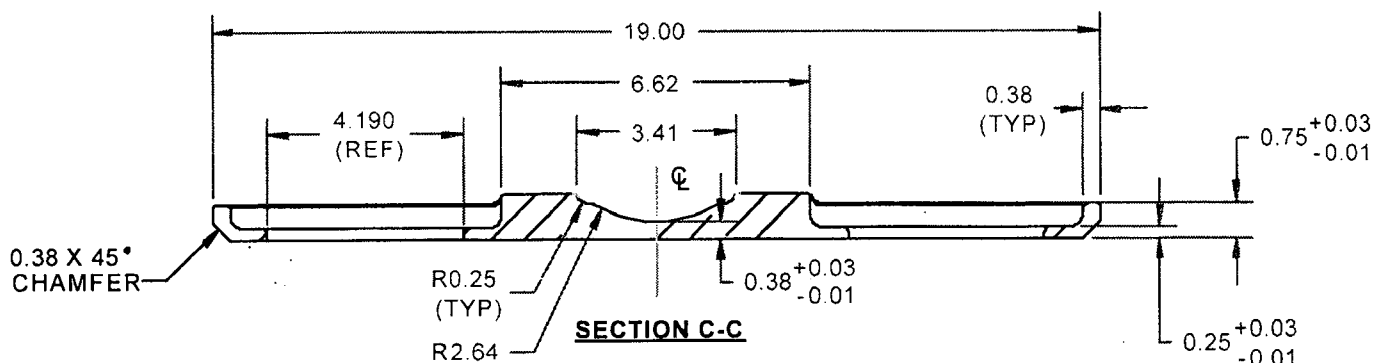
DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:4



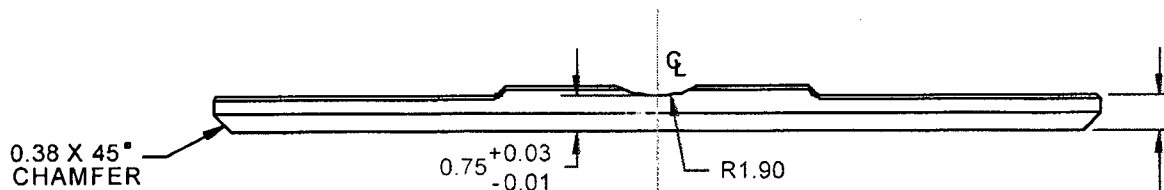
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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WORK ORDER
NO. 32835

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Date: Wednesday, 6/6/2007 3:45:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 BEARPAW INSTALLATION KIT (48")
Job Number	: 32835		
Estimate Number	: 12283		
P.O. Number	:	Part Number	: D205564011
This Issue	: 6/6/2007 S.O. No. :	Drawing Number	: D2521
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: J
Previous Run	: 30338	Material	:
Written By	:	Due Date	: 7/10/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>07.06.07</u>		
Comment	: Est F 00'01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

07.06.14

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 13.6500 sf(s)/Unit Total : 136.5000 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 (2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

REFERENCE ONLY

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Friday, 04/04/2008 2:47:06 PM
Melanie Fauteux

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : UPDATE PAPERWORK
Job Number : 38417	
Estimate Number : 10804	
P.O. Number :	Part Number : D205564011
This Issue : 04/04/2008 S.O. No. :	Drawing Number : ECN1170
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 00015	Material :
Written By : <u>mf</u>	Due Date : 11/04/2008 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
PULL FROM STOCK
D205-564-011 B _____



B35062 B36690
B35062 B36690
B35062 B32835
B35062 B32835
B35062 B32835
B32835 B32835
B32835 B32835
B36690
B36690
B36690

ADD TO KITS IN STOCK FAA STC SR00571NY
FMS TO BE REINSTATED
PER ECN1170

RETURN KITS TO STOCK

update completed
(x17) 08/04/08

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



08/04/14

Job Completion



mf 08-04-10

W

1941

1942

1943

1944

1945

1946

1947

1948

1949

1950